

Work Order ID 97665

97665

Page 1

February-21-13 12:39:39 PM

Item ID: D3017-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Back Frame Assembly

Stop

NS2

Start Date: 2/21/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/21/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M6J

Date: 13-02-26

QC: _____

Tooling: _____

Date: _____

Run

Start

NR1

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

D3017

Rev B

100 Weld per dwg A/R 4130 rod Batch: M118875 0.00

100

Large Fab

0.00

Large Fab

Memo
1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

02 13-3-20

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

Memo 0.00

QC Quality Control

13-03-20

DAS
09
09

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|--|------|--|---|------------------------------------|--|--|--------------|--------------|---|---|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube | | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio | | | Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions | | | Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled |
| | | | | | | | | | | <input type="checkbox"/> Other | |
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Work Order ID 97665

97665

Page 2

February-21-13 12:39:39 PM

| | | | | | | | | |
|-----------------------|---------------------|-------------------|---------------------|--------------|----------------------|--------------|--------------|--|
| Item ID: | D3017-041 | Accept | *N900040100* | Setup | Start | *NS1* | | |
| Revision ID: | | | | | | Stop | *NS2* | |
| Item Name: | Back Frame Assembly | | | | | | | |
| Start Date: | 2/21/13 | Start Qty: | 1.00 | *1* | Cust Item ID: | | | |
| Required Date: | 2/21/13 | Req'd Qty: | 1.00 | *1* | Customer: | | | |

Reference:

| | | | | | | | |
|-------------------|----------------------|--------------|-------------------|--------------|------------|--------------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | | | | | | Stop | |
| | QC: | Date: | SPC (Y/N): | Date: | | | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|--|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|
| 120 *120* QC | QC5- Inspect part completeness to step on W/O Quality Control | 0.00 | | | | | | | DAU 09 8-89 |
| | Memo | 0.00 | | | | | | | |

| | | | | | | | | | |
|-----------------------------------|----------------|--|-------|-------|---|--|--|--|--|
| 130 *130* Powdercoat | Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 | 0.00 | | | | | | |
| | | Memo | 12:00 | 0.00 | | | | | |
| | | START TIME: | 12:00 | 3200L | = | | | | |
| | | OVEN TEMPERATURE: | | | | | | | |
| | | FINISH TIME: | 12:30 | | | | | | |
| | | Memo | | | | | | | |

W122ab6

| | | | | | | | | | |
|---------------------------|-----------------|--------------------------|------|--|--|--|--|--|--|
| 140 *140* QC | Quality Control | QC3- Inspect Part Finish | 0.00 | | | | | | |
| | | Memo | | | | | | | |

1x/ m/l 13/03/20

1x / M 13/03/20

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|--|------|--|---|------------------------------------|--|--|--------------|--------------|---|---|
| | | | Rework <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | |
| | | | Scrap <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | |
| | | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | |
| | | | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube | | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio | | | Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions | | | Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled |
| | | | | | | | | | | <input type="checkbox"/> Other | |
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NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | |
|--|------|------|---|--|--|--|---|--------------|--------------|--|---|--------------------------------|
| | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/> | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | <input type="checkbox"/> Other |

Picklist Print

February-21-13 12:39:38 PM

Page 1

Work Order ID: 97665

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 2/21/13

Required Date: 2/21/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19 New issue EC
IPP RevB: as per revB DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M4130NT0.750W.083 4130 RD Tube .750 x.083W | | Purchased | No | | | 100 | f | 23.5026 | 2.458 | 2.5873684 | | EL 13-3-20 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | MAT033 | | | 23.5026316 | | | | | | |
| | | | | 117973 | | | 0.0026316 | | | | | | |
| | | | | 124293 | | | 23.5 | | | | | | 2.58 |
| M4130NT0.750W.049 4130 RD Tube .750 x.049W | | Purchased | No | | | 100 | f | 111.7718 | 11.125 | 11.710526 | | EL 13-3-20 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | MAT033 | | | 111.7717893 | | | | | | |
| | | | | 123339 | | | 9.6217893 | | | | | | |
| | | | | 124293 | | | 102.15 | | | | | | 11.7 |
| D3017-11 cap | | Manufactured | No | | | 100 | Each | 48.0000 | 2 | 2 | | EL 13-3-20 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | WA002 | | | 48 | | | | | | |
| | | | | 91837 | | | 48 | | | | | | 2 |
| D3017-7 Lug | | Manufactured | No | | | 100 | Each | 21.0000 | 3 | 3 | | EL 13-3-20 | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | | | | | |
| | | | | WA002 | | | 21 | | | | | | |
| | | | | 86873 | | | 2 | | | | | | |
| | | | | 88460 | | | 19 | | | | | | 2 |

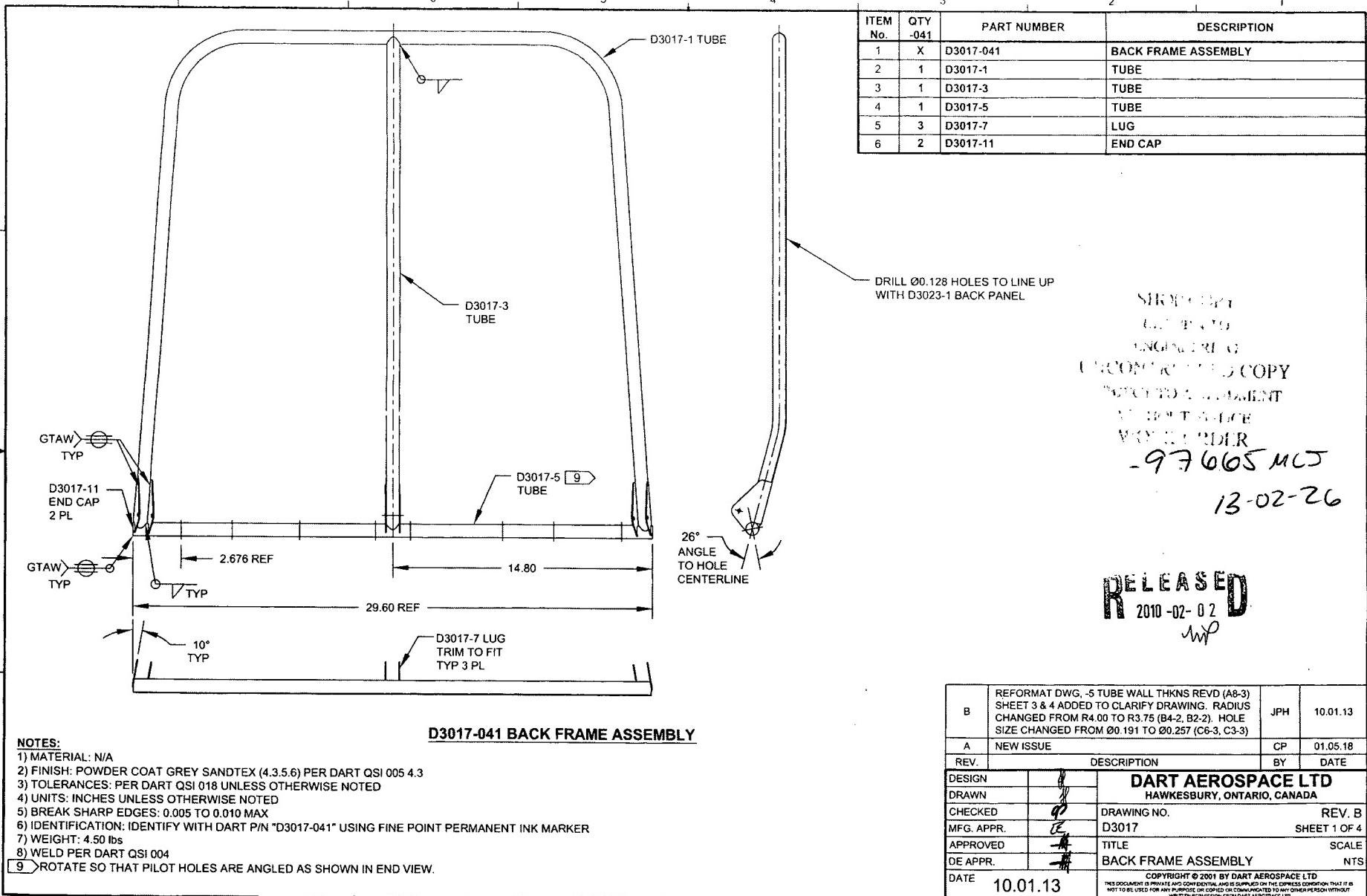
NCR: Yes / No

DQA: _____ Date: _____

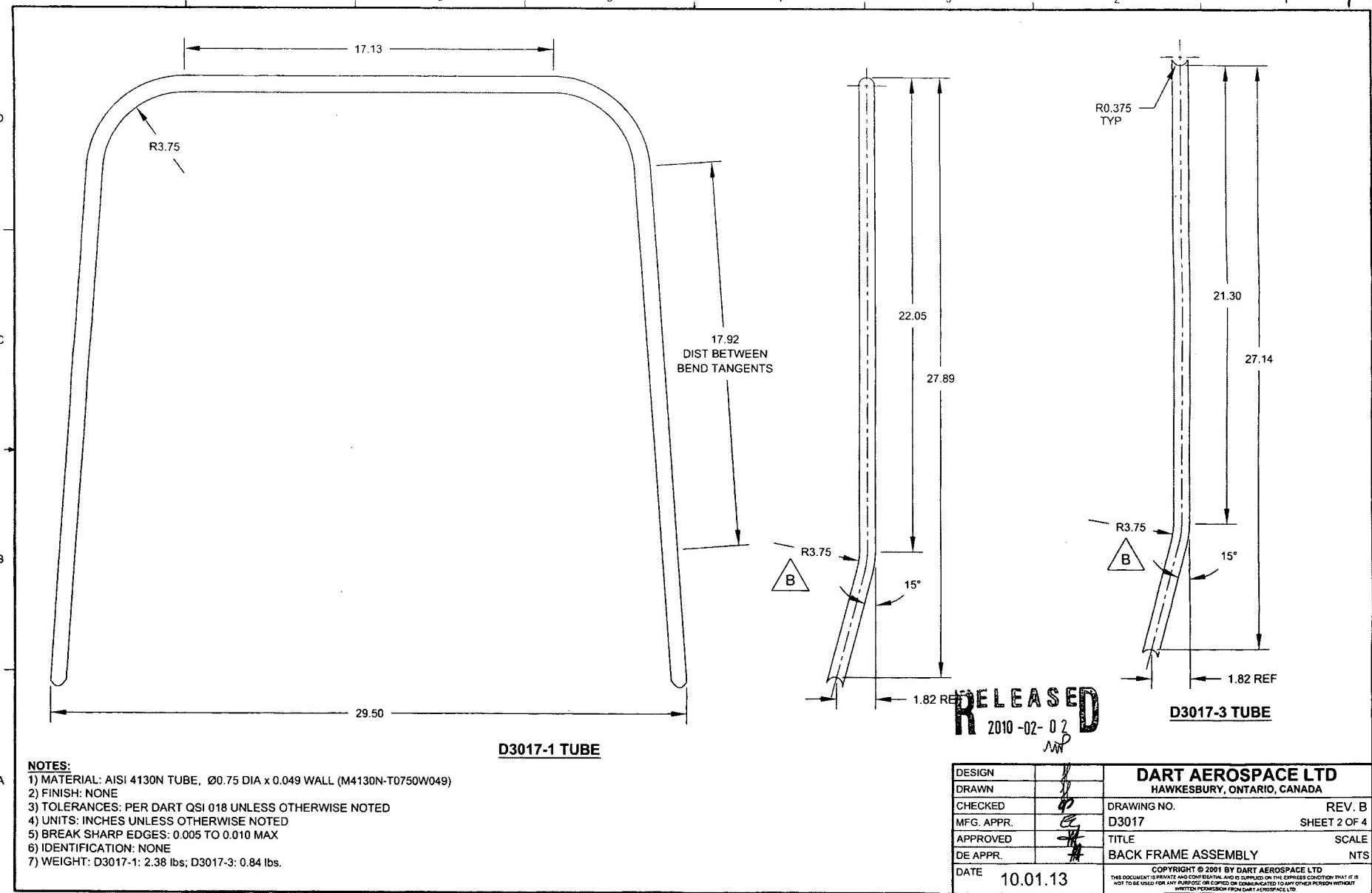
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|-------------------|---|--|--|---|---|------------------------------------|--|---|--------------------------------------|--------------|
| Part No. _____ | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Machining <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | |
| NCR No. _____ | | Work Order Update <input type="checkbox"/> | | | Thermoforming <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | |
| | | | | | Composite <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Other <input type="checkbox"/> | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear | General | | | | | | | | | |
| | Bending <input type="checkbox"/> | Bend <input type="checkbox"/> | Grain <input type="checkbox"/> | Ovalized <input type="checkbox"/> | Pressure/Forced <input type="checkbox"/> | | | | | |
| | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/> | Hardware <input type="checkbox"/> | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/> | | | | | |
| | Cracks <input type="checkbox"/> | Broken/Damaged <input type="checkbox"/> | Inspection Incomplete <input type="checkbox"/> | Part Incorrect <input type="checkbox"/> | Weld <input type="checkbox"/> | | | | | |
| | Crushed/Crimped. <input type="checkbox"/> | Burrs <input type="checkbox"/> | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/> | | | | | |
| | Cuffs <input type="checkbox"/> | Contamination <input type="checkbox"/> | Maintenance <input type="checkbox"/> | Part Moved <input type="checkbox"/> | | | | | | |
| | Heat Treat <input type="checkbox"/> | Countersink <input type="checkbox"/> | Mislabeled <input type="checkbox"/> | Positioned Wrong <input type="checkbox"/> | | | | | | |
| | Inspection Strip in Tube <input type="checkbox"/> | Cut Too Short <input type="checkbox"/> | Misread <input type="checkbox"/> | Power Loss/Surge <input type="checkbox"/> | | | | | | |
| | Ripples in Bend <input type="checkbox"/> | Drill Holes <input type="checkbox"/> | Offset <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | |
| | Torque Waves in Extrusion <input type="checkbox"/> | Drawing <input type="checkbox"/> | Out of Calibration <input type="checkbox"/> | | | | | | | |
| | Turning Sequence <input type="checkbox"/> | Finish <input type="checkbox"/> | Out of Sequence <input type="checkbox"/> | | | | | | | |
| | Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/> | Outside Dimensions <input type="checkbox"/> | | | | | | | |



97665



| | | |
|------------|----------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. B |
| MFG. APPR. | | D3017 SHEET 2 OF 4 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | BACK FRAME ASSEMBLY NTS |
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97665

8 7 6 5 4 3 2 1

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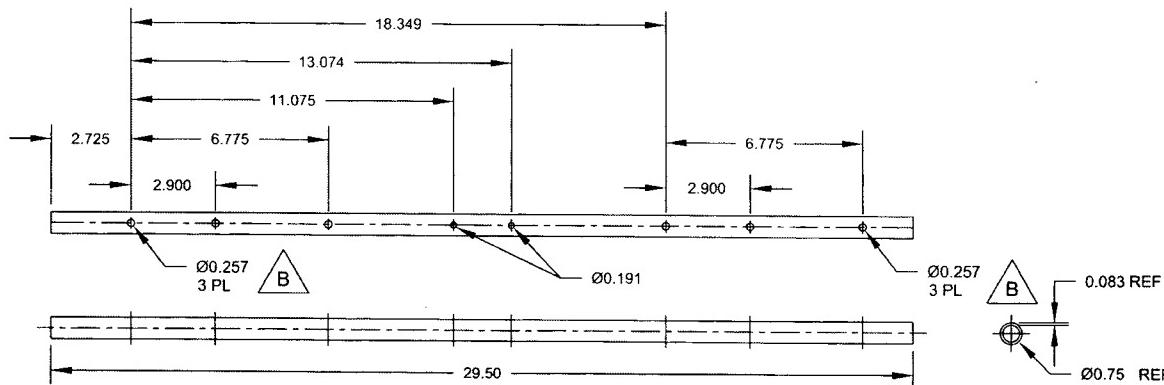
D

C

C

B

B



D3017-5 TUBE

RELEASED
2010-02-02
AMP

A NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs

B

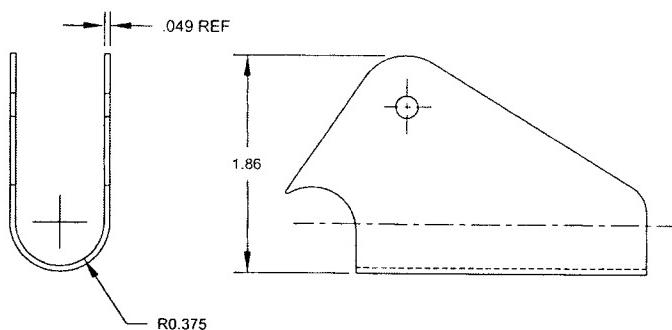
8 7 6 5 4 3 2 1

| | | |
|------------|----------|-----------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | REV. B |
| MFG. APPR. | | DRAWING NO. |
| APPROVED | | SHEET 3 OF 4 |
| DE APPR. | | TITLE |
| DATE | 10.01.13 | SCALE |
| | | BACK FRAME ASSEMBLY NTS |

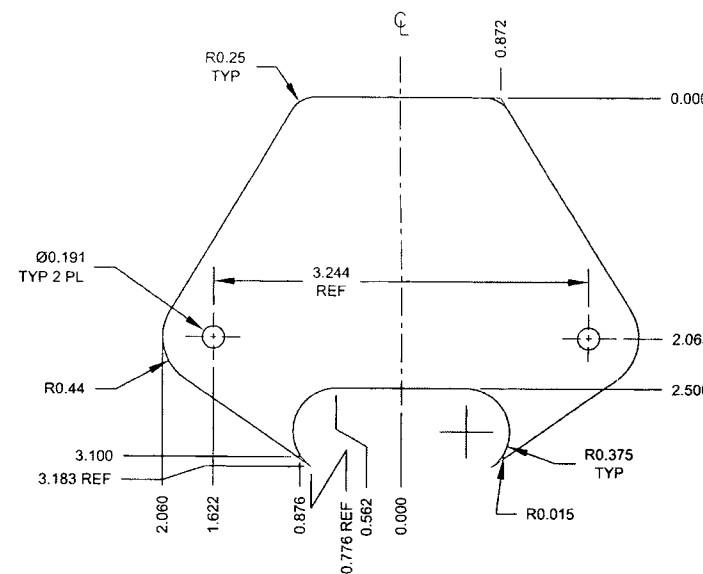
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A

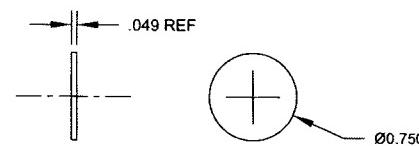
97665



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE



D3017-11 END CAP

RELEASED
R 2010-02-02
M

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

| | | |
|------------|--------------------|--------------------------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | REV. B |
| MFG. APPR. | <i>[Signature]</i> | DRAWING NO. D3017 SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE |
| DE APPR. | <i>[Signature]</i> | SCALE |
| DATE | 10.01.13 | BACK FRAME ASSEMBLY NTS |

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